

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012966**Date Inspected:** 09-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 10**

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint NSTL4-3B/L-5A located outside PCMK north tower, lift 4, skins B/C corner at Y=2500. The excavation appeared to be 38mm deep x 45mm wide x 220mm long. Welder was identified as 057258. QC was identified as ZPMC CWI Du Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-repair. However, the ZPMC Critical Weld Repair Report presented to this QA Inspector displayed no documentation number or apparent Caltrans approval. This QA Inspector generated a Caltrans Incident Report concerning this issue. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan. This QA Inspector notified QC1 and ABF Representative Li Nan of the above noted Caltrans Incident Report.

**Bay 11**

This QA Inspector randomly observed no apparent welding work in progress in Bay 11.

**Heavy Dock**

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

## WELDING INSPECTION REPORT

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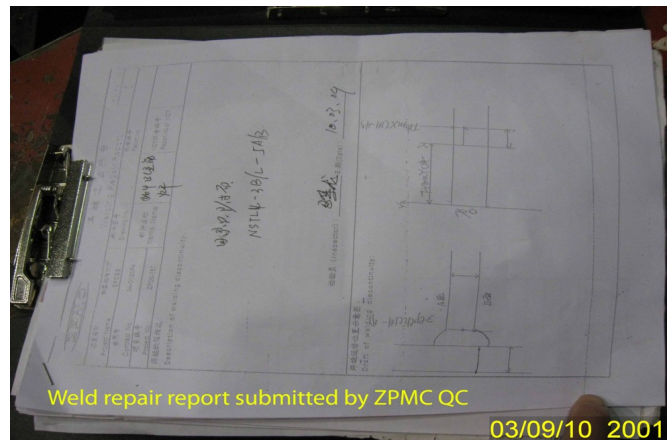
FCAW welding of weld joint SSD1-SA17F/G-84 located outside PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 053870. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSD1-SA17F/G-74 located outside PCMK south tower, lift 1 base, skin C, shear plate stiffener to connection plate. Welder was identified as 057244. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding of weld joint SSD1-SA18-34 located outside PCMK south tower, lift 1 base, skin B, shear plate stiffener to connection plate. Welder was identified as 053869. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC He Gen, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

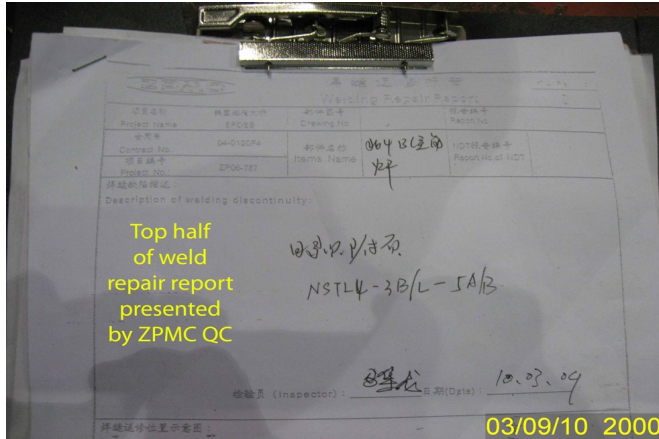
The tower trial assembly elevator appeared to be dark and innoperative.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



# WELDING INSPECTION REPORT

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Top half of weld repair report presented by ZPMC QC

03/09/10 2000



## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

**Inspected By:** Goulet, George

Quality Assurance Inspector

**Reviewed By:** Dawson, Paul

QA Reviewer